

5/35

DART AEROSPACE LTD	Work Order:	23975
Description: Head Rest	Part Number:	D3303-041
Dwg: D3303 Rev. A	Qty:	5
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																
1	DC	Issue Traveler	HA	05.08.08	5																
2	GA	Bond foam to D3303-043 bracket assembly as per Dwg D3303 using 3M 1300/1300L or 8046 adhesive Pick: <table border="0"> <tr> <td><u>Qty</u></td> <td><u>Part Number</u></td> <td><u>Description</u></td> <td><u>Batch</u></td> </tr> <tr> <td>1</td> <td>D3303-043</td> <td>Bracket Assembly</td> <td>B24712</td> </tr> <tr> <td>1</td> <td>D3305-1</td> <td>Foam</td> <td>B23981</td> </tr> <tr> <td colspan="3">A/R 3M 1300/1300L or 8046 Adhesive</td> <td>MT8532</td> </tr> </table> Identify as D3303-041	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	1	D3303-043	Bracket Assembly	B24712	1	D3305-1	Foam	B23981	A/R 3M 1300/1300L or 8046 Adhesive			MT8532	SB	06/04/20	5
<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>																		
1	D3303-043	Bracket Assembly	B24712																		
1	D3305-1	Foam	B23981																		
A/R 3M 1300/1300L or 8046 Adhesive			MT8532																		
3	GA	Cover Head Rest with D3306-041 as per Dwg D3303 Pick: <table border="0"> <tr> <td><u>Qty</u></td> <td><u>Part Number</u></td> <td><u>Description</u></td> <td><u>Batch</u></td> </tr> <tr> <td>1</td> <td>D3306-041</td> <td>Cover Assembly</td> <td>B23982</td> </tr> </table>	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	1	D3306-041	Cover Assembly	B23982	SB	06/04/20	5								
<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>																		
1	D3306-041	Cover Assembly	B23982																		
4	QC5	Inspect work to Step 3		06-04-20	5																
5	ST	Identify parts with batch number and part number, also identify the back of the headrest with TCCA-PDA # PDA04-11 using a fine point permanent marker as per Dwg D3304 and Stock 51381		06/04/20	(5)																
6	AC	Cost / part: _____	U	06-04-21	5																
7	DC	Close W/O Inspect Level 21		06/04/21	5																

Rev	Date	Change	Revised By	Approved
A	04.09.07	New Issue	KJ/JLM	
B	04.10.05	Revised Step 5 with headrest identification	KJ/JLM	

RELEASED
 06/04/10-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/04/21

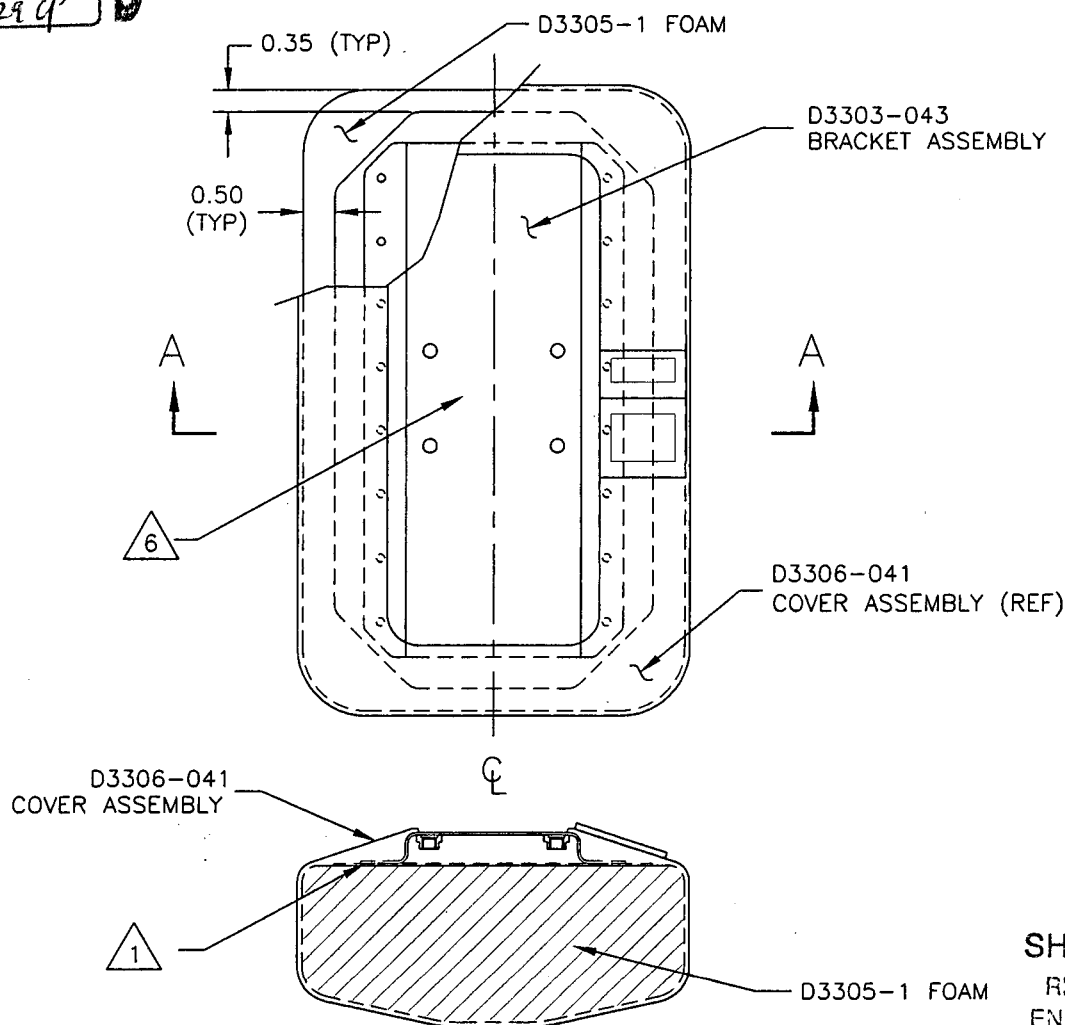
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3303	REV. A SHEET 1 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:3
A	04.08.18	NEW ISSUE	

RELEASED
04.09.29 CP



SECTION A-A

D3303-041 HEAD REST

D3303-041 NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" to 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 AS SHOWN
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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WITHOUT NOTICE

WORK ORDER

NO. 23975

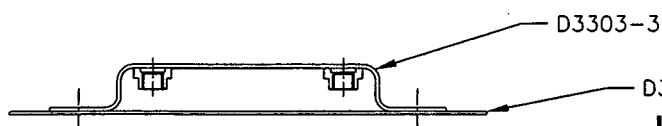
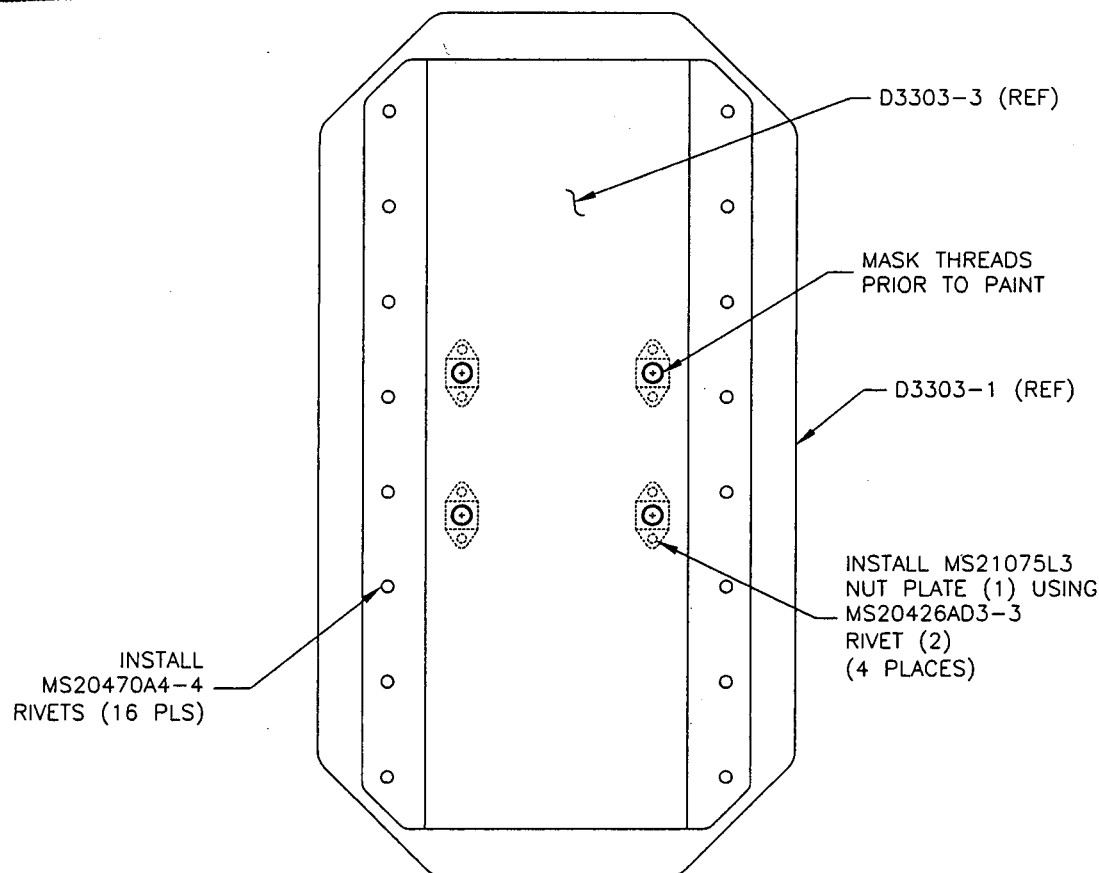
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3303	REV. A SHEET 2 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:1

RELEASED
04.09.29 DP



D3303-043 BRACKET ASSEMBLY

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WORK ORDER
NO. 23975

D3303-043 NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

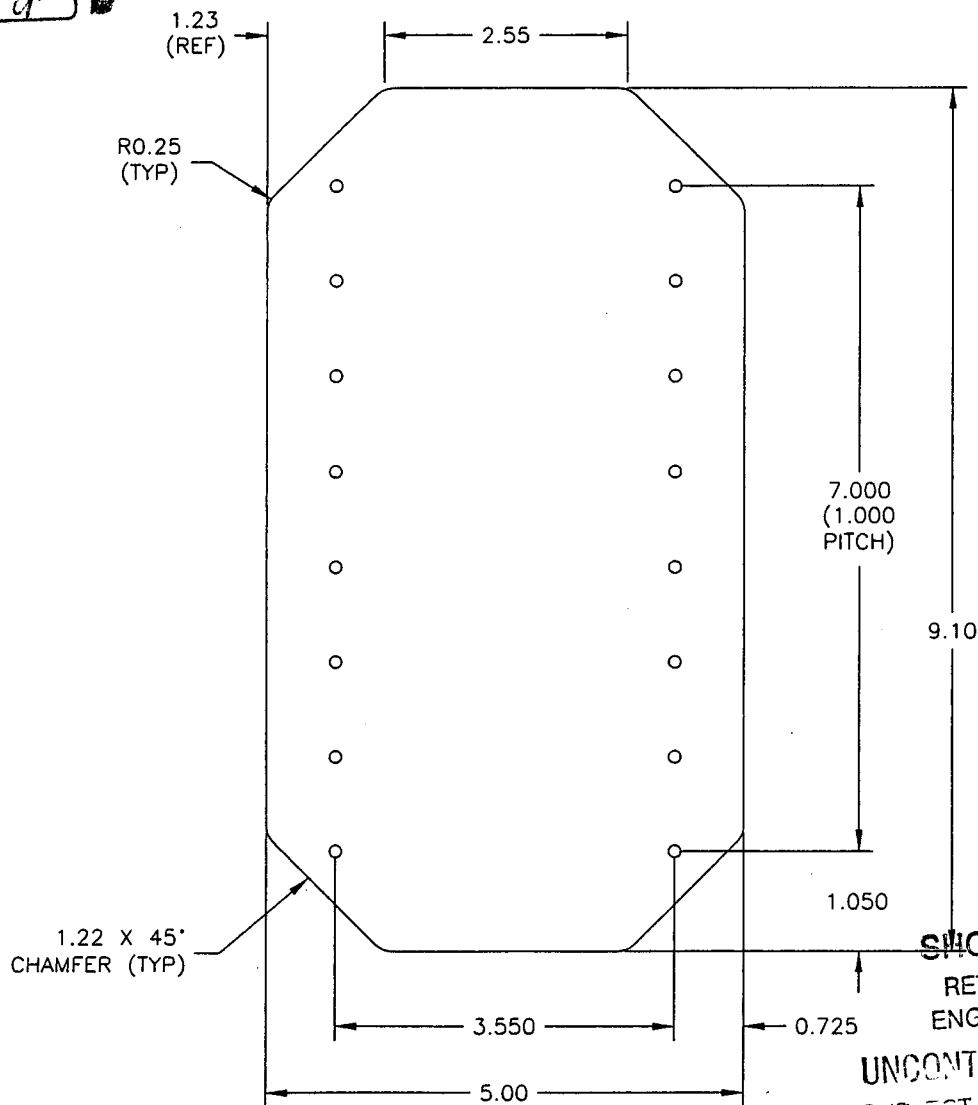
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. A SHEET 3 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

RELEASED
04.09.29 *UP*



D3303-1 PLATE

D3303-1 NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET (REF. DART SPEC M2024T32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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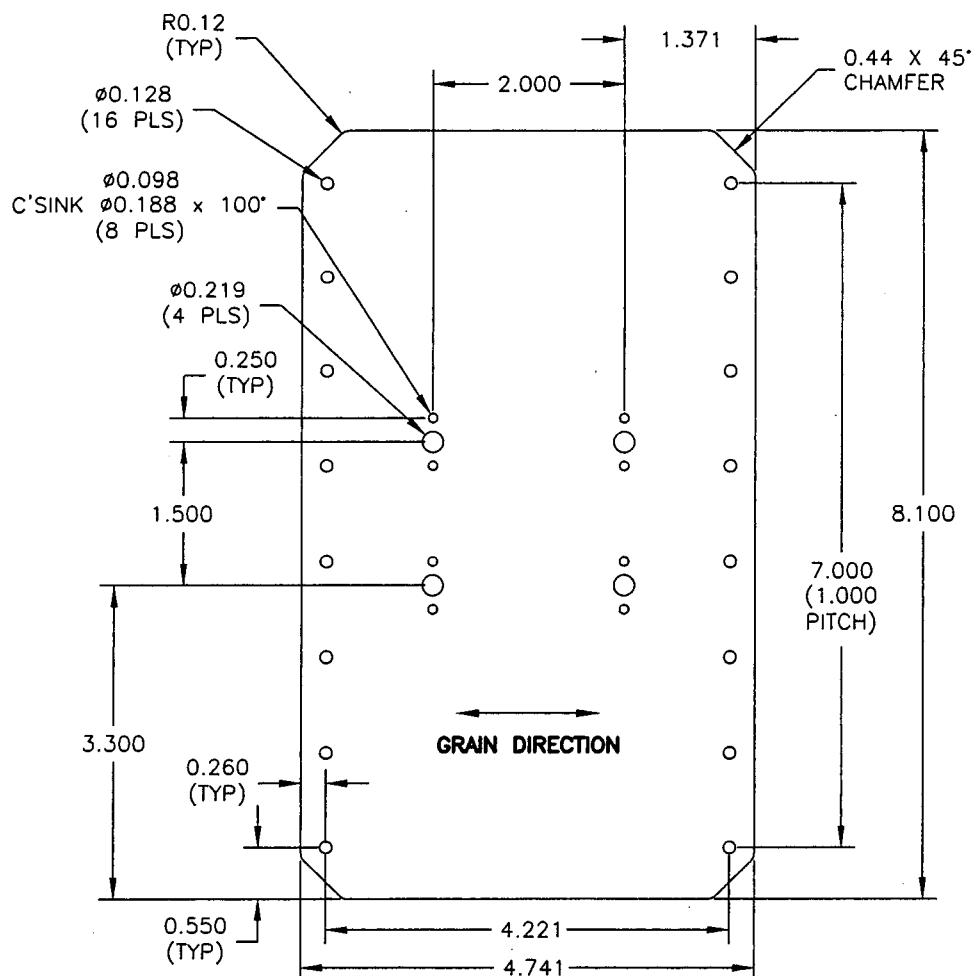
WORK ORDER
NO. 23975

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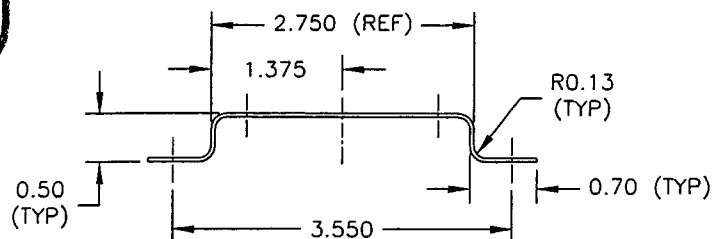


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RT	APPROVED RT	DRAWING NO. D3303	REV. A SHEET 4 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:2



D3303-3 FLAT PATTERN

RELEASED
04.09.29 CP



D3303-3 BRACKET
BEND DETAIL

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SL T T AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 23975

D3303-3 NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC M2024T32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 08, 2005
10:50 am

Work Order No : 0023975
Project Name : D3303-041
Project For : WK535
Work Order Type : Main
Main WO Number :
House Part Number : D3303-041
Description : Head Rest
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 08-08-05
Est Finish Date : 08-31-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Date: Saturday, 11/19/2005 10:07:00 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HEAD REST
Job Number	: 23975		
Estimate Number	: 10738		
P.O. Number	:	Part Number	: D3303041
This Issue	: 11/19/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3303 REV. A
First Issue	: / /	Project Number	:
Previous Run	:	Drawing Revision	: A
Written By	:	Material	:
Checked & Approved By	:	Due Date	: 11/25/2005
Comment	: Est: B 04.10.05 Revised Step 5 with headrest indentification K J/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3303043	Bracket Assembly
2.0	D33051	Cushion
3.0	D3306041	Cover Assembly
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

- 1- Bond foam to D3303-043 bracket assembly as per Dwg D3303 using 3M 1300/1300L or 8046 adhesive.
Identify as D3303-041
- 2- Cover Head Rest with D3306-041 as per Dwg D3303

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP

6.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

- Identify with P/N and B/N, also identify the back of the headrest with TCCA-PDA # PDA04-11 using a permanent fine point marker as per Dwg D3303, then Stock
- Location: _____

7.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

Inspection Level 21

Job Completion



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:47 am

Work Order No : 0023975
Project Name : D3303-041
Project For : WK535
Work Order Type : Main
Main WO Number :
House Part Number : D3303-041
Description : Head Rest
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 08-08-05
Est Finish Date : 08-31-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00